

Date: Tuesday, 12/20/2005 3:21:01 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SPACEPOD BODY RH  
 Job Number : 25302A  
 Estimate Number : 11102  
 P.O. Number : N/A Part Number : D31882  
 This Issue : 12/20/2005 S.O. No. : N/A Drawing Number : D3186 REV A  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : 12/20/2005 Type : SMALL /MED FAB Drawing Revision : A  
 Previous Run : 25301A Material : N/A  
 Written By : SEE COMMENT BELOW Due Date : 1/20/2006 Qty: 1 Um: Each  
 Checked & Approved By : SEE ABOVE USER & DATE  
 Comment : Est Rev:A New Issue 05-11-29 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2213 Aluminum Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)  
 Ship To Delastek

8 D2213 Spacer

Batch: B22997A

1 05.12.21 JZ (1)

2.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 00000324

Description: D3188-2 BODY

SHIP LABEL D0600-142 & D2213 Spacers

Supplier: Delastek

Conformity Certificate and Process sheet required

Ship 2 Items from Previous steps

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.

C206/03/28 (1)

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3188 .Visual inspection. Check for void spot and pins.

10  
1  
10-04-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/04/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>06/04/04</u>	<u>3</u>	<u>Pool body doesn't conform with the dwg.</u>	<u>[Signature]</u>	<u>Body is good. Dwg to be under review by engineering for new hole dimensions. Engineering notified.</u>	<u>[Signature]</u> <u>06/04/04</u>	<u>[Signature]</u> <u>06/04/04</u>	<u>[Signature]</u>	<u>[Signature]</u> <u>06/04/04</u>
				<u>Also see NCR 032</u>				

NOTE: Date & initial all entries

Date: Tuesday, 12/20/2005 3:21:01 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD BODY RH

Job Number: 25302A

Part Number: D31882

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



*2604.04* (1)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: CA

6.0

DC

DOCUMENT CONTROL



*2604.05* (1)

Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



*2604.05*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN JB	DRAWN BY <i>CP</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3188	REV. A SHEET 1 OF 7
DATE 03.04.03		TITLE SPACEPOD BODY	SCALE NTS
A	03.04.03	NEW ISSUE	

RELEASED  
03.04.22

**GENERAL NOTES:**

1. REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
2. LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
3. MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)  
12 oz UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")  
18 oz ROVING "E" GLASS (18 oz CLOTH)  
OWENS CORNING MILLED FIBERS, "E" GLASS  
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL  
OR DIVINYCELL  
OR AIREX  
OR KLEGECELL  
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

4. MOLD SCHEDULE:

<u>PART</u>	<u>LAYUP</u>	<u>TRIM AND DRILL</u>
D3188-1	DT8003	DT8501
D3188-2	DT8004	DT8502
D3188-3	DT8500	DT8501

5. APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
6. FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S

NOT COPY  
TO  
COPY

25302 A

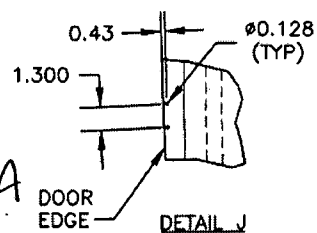
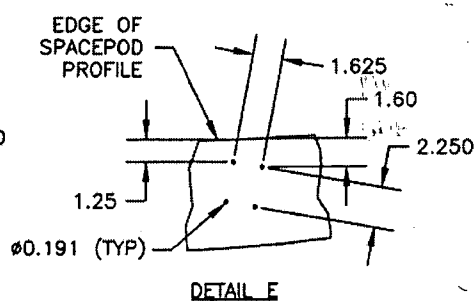
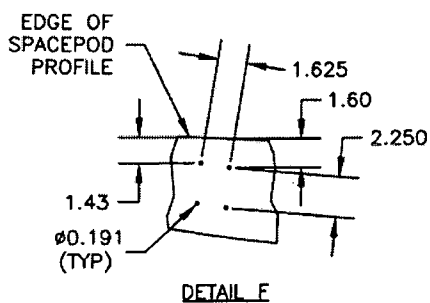
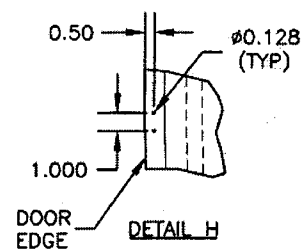
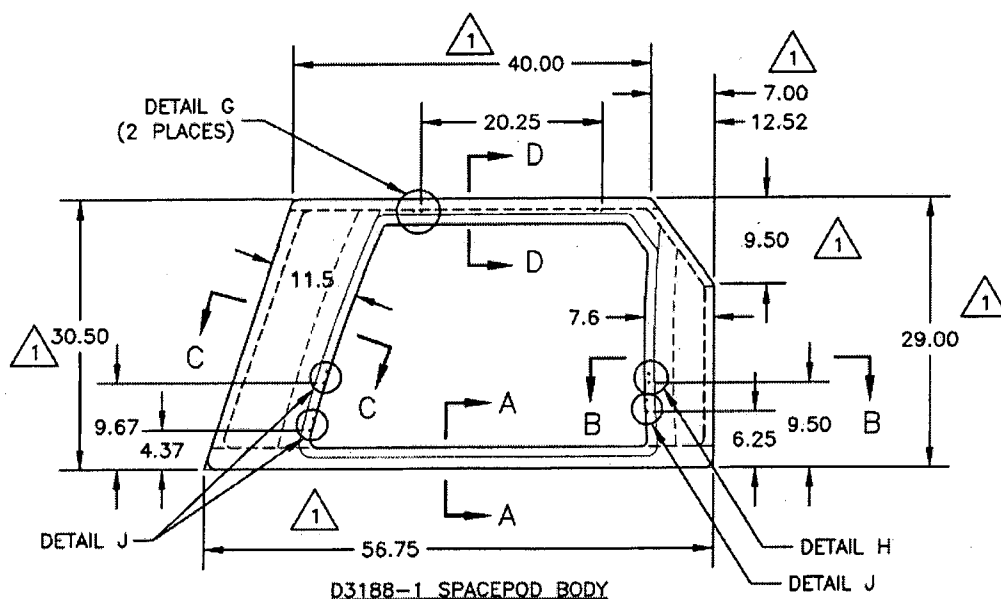
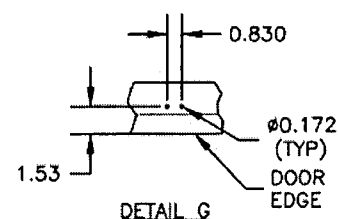
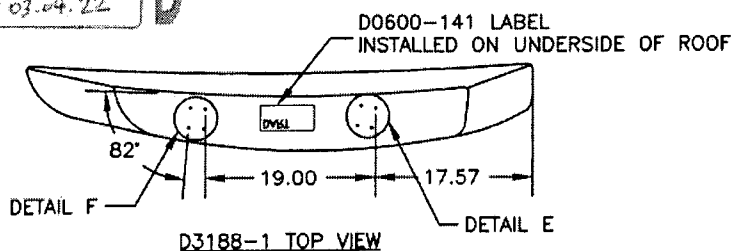
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DATE 03.04.03	TITLE SPACEPOD BODY	SCALE NTS	

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# 03.04.22



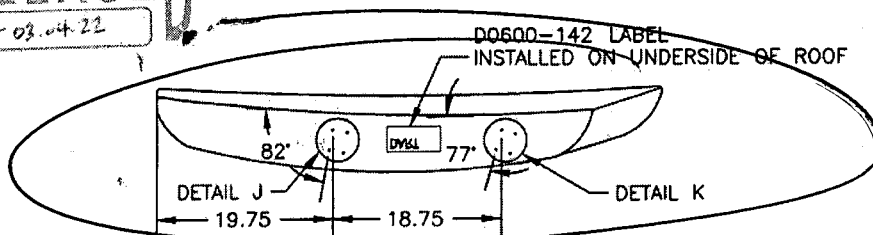
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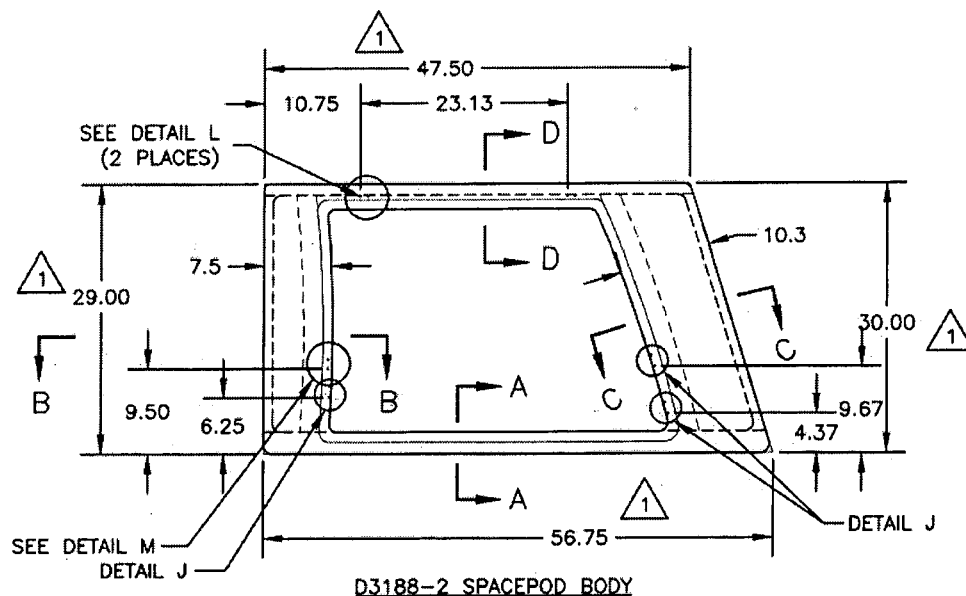


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DATE 03.04.03	TITLE SPACEPOD BODY		SCALE NTS

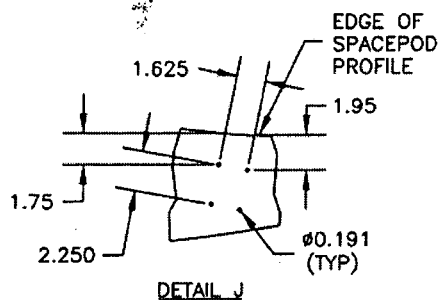
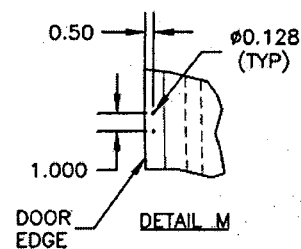
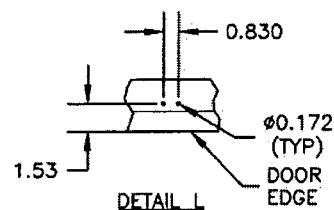
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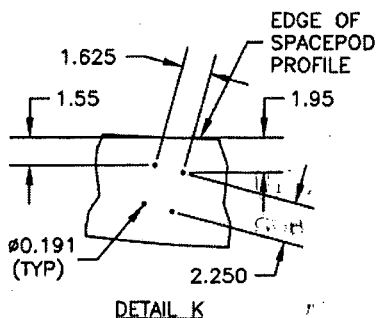
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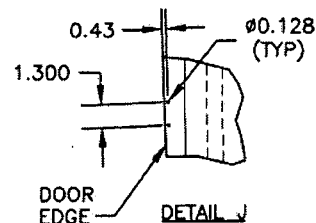
D3188-2 SPACEPOD BODY



DETAIL J



DETAIL K



DETAIL J

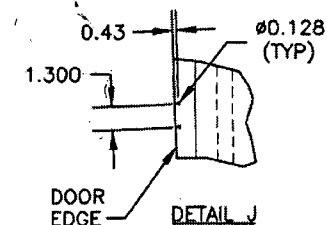
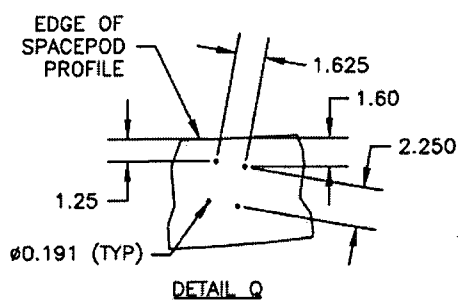
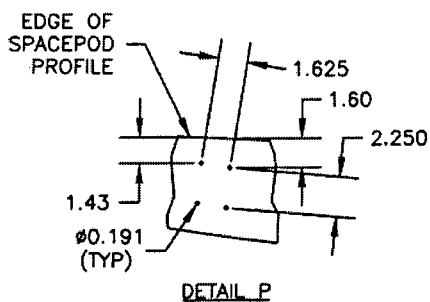
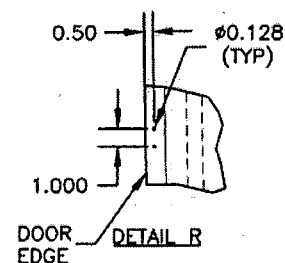
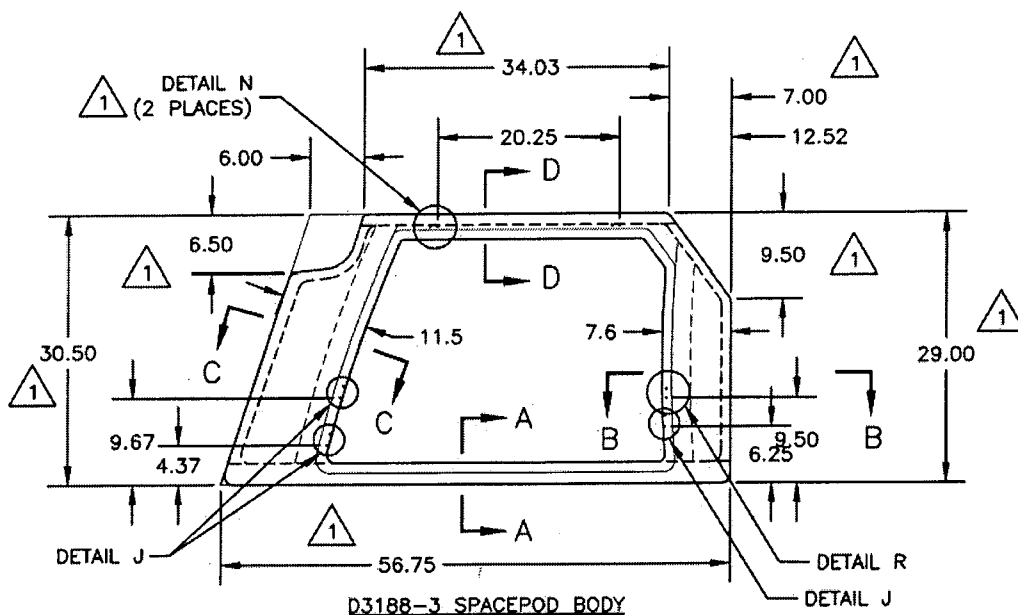
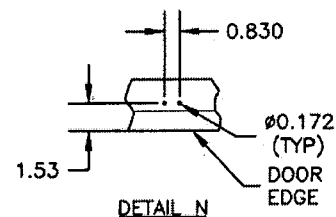
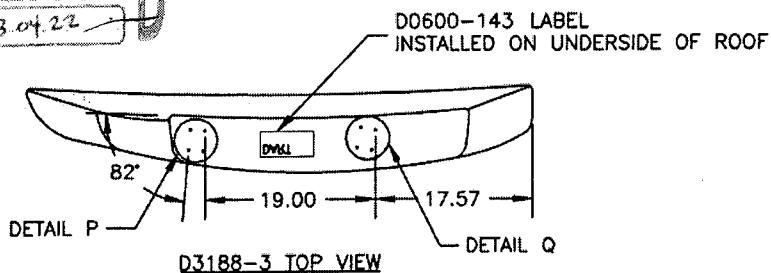
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**DART**

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DATE 03.04.03	TITLE SPACEPOD BODY		SCALE NTS

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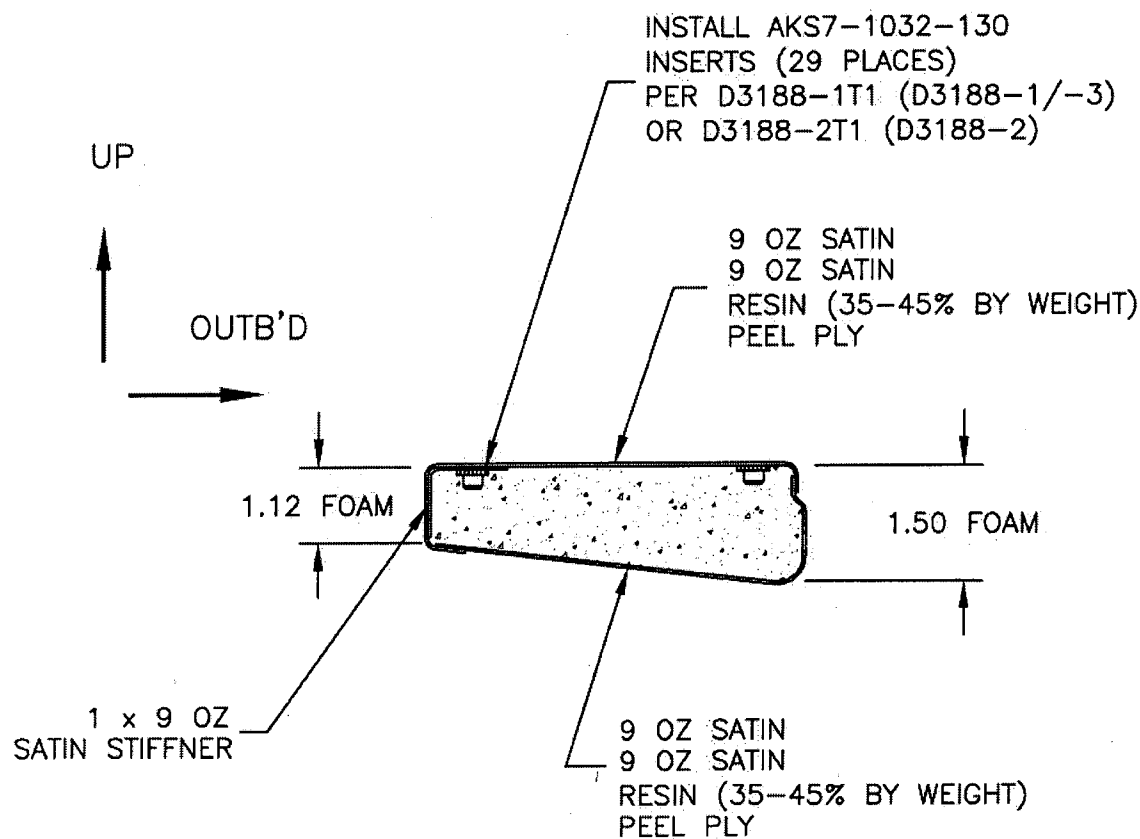
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DATE 03.04.03		TITLE SPACEPOD BODY	SCALE NTS

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SECTION A-A  
(TYPICAL FLOOR SECTION)

25302A

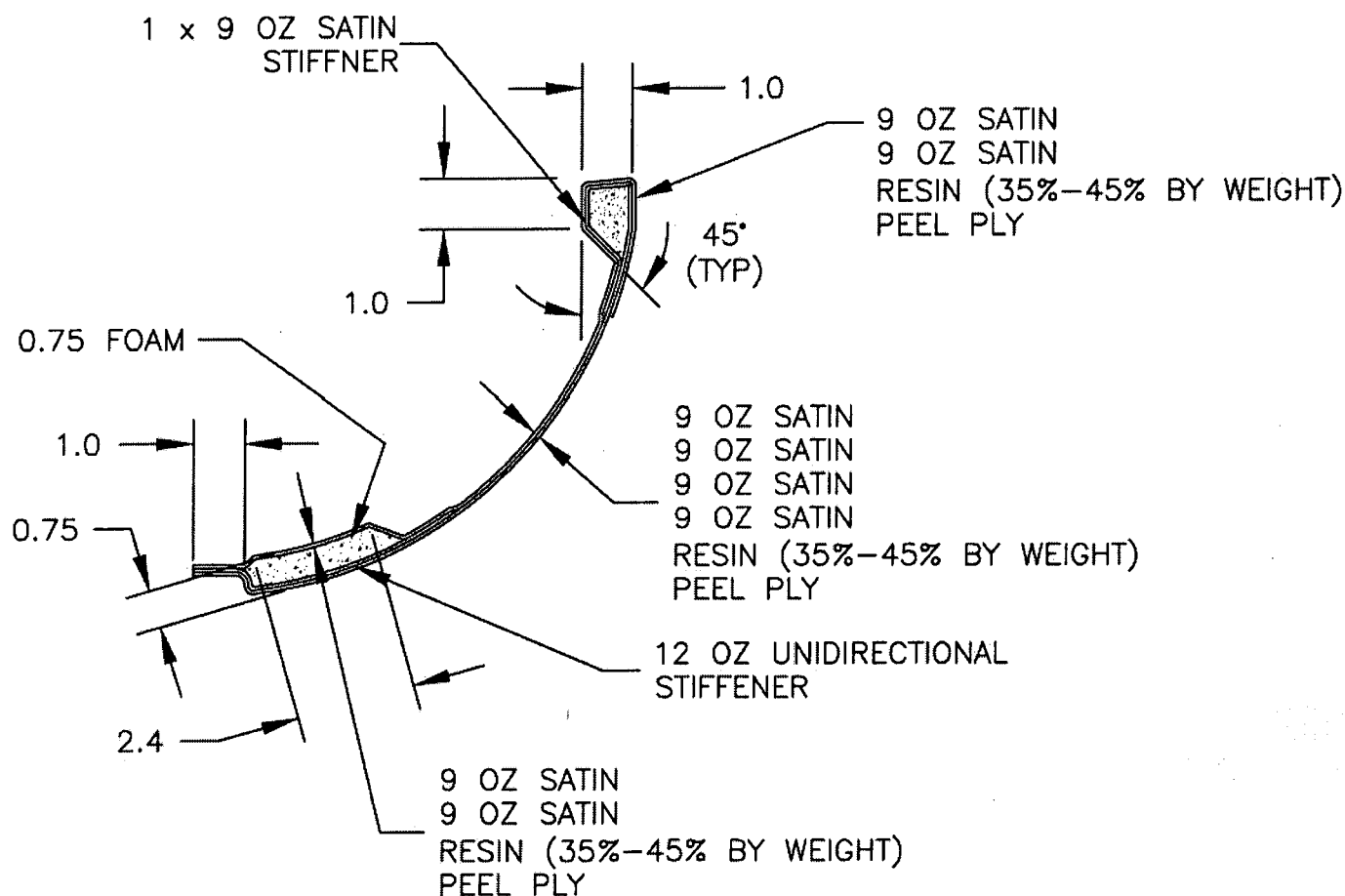
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DATE 03.04.03		TITLE SPACEPOD BODY	SCALE NTS

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SECTION B-B  
(SECTION C-C SIMILAR)

NO. 25302A

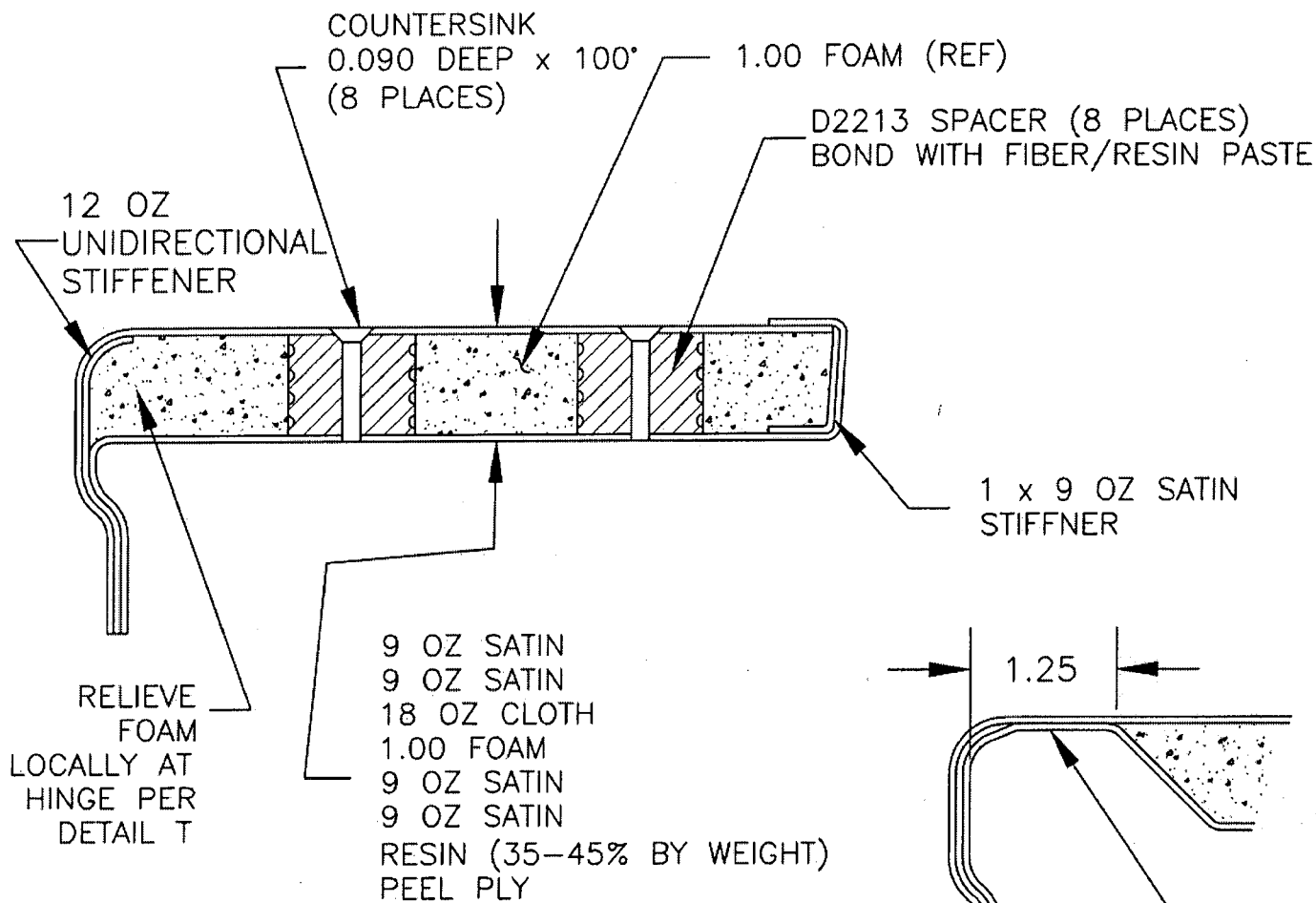
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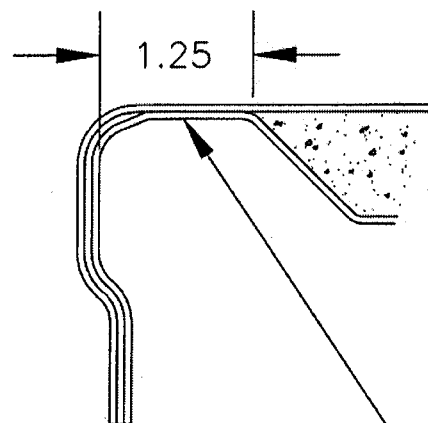


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CHECKED #	APPROVED C	DRAWING NO. D3188	REV. A SHEET 7 OF 7
DATE 03.04.03		TITLE SPACEPOD BODY	SCALE NTS

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03.04.22



SECTION D-D  
(TYPICAL ROOF SECTION)



RELIEVE AS SHOWN  
3" LONG CENTERED  
ON HINGE

DETAIL T

W/L  
NC 25302A

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## Linda Lacelle

---

**From:** Linda Lacelle [llacelle@dartaero.com]  
**Sent:** Tuesday, March 28, 2006 2:24 PM  
**To:** 'Jocelyne Laurin'  
**Cc:** 'shamel@delastek.com'  
**Subject:** RE: RE: SHIPMENT FROM YESTERDAY

ok...here's the scoop:

- for P.O 324 we will use B/N 25300 for the door we received, you will have to supply us the body with the same B/N 25300
- for the D3188-2/86-2 we will use B/N 25302 - the one left to deliver on this P.O 324 - you will have to supply us with the B.N 25301
- for P.O 610 you can only use the B/N's issued on the P.O 25851 and 25852

Thx  
Linda

-----Original Message-----

From: Jocelyne Laurin [mailto:jlaurin@delastek.com]  
Sent: Tuesday, March 28, 2006 8:56 AM  
To: 'Linda Lacelle'  
Cc: shamel@delastek.com  
Subject: RE : SHIPMENT FROM YESTERDAY

Bonjour Linda,

For p.o. #324 D3186-1, can you please use label #B25851, since the spacepod body LH will have the label #B25851.

As for D3188-2 / D3186-2 - with label 24307, you can use either B26064, B26065 or B25302. Please advise which one you will use.

>From now on, we will mark our W/O and our B/N on the packing slips.

Please note that on your order #610, for the second set of spacepod door and Body LH, we will use label #B25300, since we already used the label #B25851 on po #324.

Thanks and have a nice day.

Jocelyne Laurin  
Service à la Clientèle/Customer Service  
Tel: 1-819-533-5788 p. 221  
Fax: 1-819-533-3494

-----Message d'origine-----

De : Linda Lacelle [mailto:llacelle@dartaero.com]  
Envoyé : March 24, 2006 9:18 AM  
À : Jocelyne Laurin (E-mail); Mgodin@Delastek.Com (E-mail);  
Sheroux@Delastek.Com (E-mail)  
Cc : Jason Murdoch (E-mail)  
Objet : SHIPMENT FROM YESTERDAY  
Importance : Haute

we received a few items yesterday, but were all mixed up...p.o 324  
D3186-1 - has a label of 21558 - this is a very old batch, and had been completed in Oct, 2005. There is no w/o marked on your packing slip or invoice...we need to know what labels you have left, so we can figure out what w/o here to attach it to.

D3188-2 / D3186-2 - has a label of 24307 - was completed in Nov., 2005, again no w/o to match from your packing slip, and again need to know what

labels you have left at Delastek, so we can assign the correct internal batch and w/o to it.

D350-604-041...we require you to mark your w/o and our B/N on the packing slips, in order to match the correct process sheets

D206-605-041 ...we require you to mark your w/o and our B/N on the packing slips, in order to atch the correct process sheets.

Please advise asap.

Thanks

Linda

Non-Conformance Report				NCR 032	
Raised by: LINDA LACEY		Source:		Sheet No. ___ of ___	
Non-Conforming Dept./Supplier: DELSTEK				Date: 06-03-29	
Product/Service: space pods D3186 / D3188				Priority: HIGH LOW	
Area of Standard:		<b>Section A</b> <b>Description of Non-Conformance</b> <p>PO 324 calls up B/N's 25299-25300-25301-25302 on P.O</p> <p>but rec'd labels in door + body 21558</p> <p>P.O 610 call up B/N's 25851-25852 on P.O</p> <p>but rec'd door &amp; body with labels 24307</p>			
QSI					
QSP					
QSPM					
Documents:					
P/O 324 / 610					
Invoice					
W/O					
Batch No. all on above					
TSR P.O's					
Drawing		Forward to Director, Quality Assurance on completion of this box			
DQA: Section B: Indicate who is responsible for creating C/A, and a completion date. Section C: Indicate who will verify completion of C/A.					
<b>Section B</b>		Responsible for Investigation/CA: _____ To be done by: _____			
<b>Corrective Action</b>					
No	Initial	Action Description	Responsible	Due date	Sign/Date
1	u	Quarantine all until B/N's resolved	JIM	06-03-24	[Signature] 06-03-29
2	u	Advise Delstek of mix up and decide what B/N to allocate associated with P.O	u / [Signature]	06-03-28	u 06-03-28
3	u	Change with a fine tipped marker correct B/N's on labels	JIM	06-03-24	[Signature] 06-03-29
4	u	Ensure Delstek knows which B/N's are <sup>still</sup> come on P.O 324 + 610	u	06-03-24	u 06-03-28
Preventive Action Required: NO YES # _____			Fault Category:		
<b>Section C</b>		Responsible for Verification of CA: _____			
<b>Verification of C/A</b>					
No	Verification Method	Sign	Date	Forward to DQA on Completion of Verification	
				DQA: _____	
				Date: _____	
QA Purposes only			N/C Closed		Date